

Date: Monday, 3/19/2007 8:16:58 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD X-TUBE EXT HEIGHT(-013)
Job Number : 31268	
Estimate Number : 10565	
P.O. Number : N/A	Part Number : D205596105
This Issue : 3/19/2007 S.O. No. : N/A	Drawing Number : D205596105
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 26842	Material : N/A
Written By : _____	Due Date : 4/10/2007 Qty: 1 Um: Each
Checked & Approved By : <u>JA 07.03.19</u>	
Comment : Est Rev: D 05.03.21 Added bending procedure KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG001

KS 07.03.26

①

2.0	D2889	FWD Crosstube
-----	-------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

1	D2889	Aft Crosstube	B29484
---	-------	---------------	--------

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

Mark 25.02 for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

27 070728

PTO

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
-----	------	------------------------------



Comment: DIMENSIONAL CHECK OF X-TUBES

07.03.20

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-105

DP 7-4-2

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

507-43

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-03-28	3.0	Cut to 32.5 as per Dwg. Perm. Change 2				<i>[Signature]</i> 07-03-28	<i>[Signature]</i> 07-03-28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:16:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 31268

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC15

DIMENSIONAL CHECK OF X-TUBES



See attached.
NIA



Comment: DIMENSIONAL CHECK OF X-TUBES

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat per QSI 005 4.1

Jb 7-4-3

8.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

ET
MA 07 04 12

(1)

9.0

QC14

Inspect Spray Paint



07 04 13 @



Comment: Inspect Spray Paint

10.0

D2856600

Abrasion Strip



Comment: Qty.: 1.4895 f(s)/Unit Total : 1.4895 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(8.51")

Abrasion Strip

26650

ET 07-04-16

11.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2893-1

Support

27475

ET 07-04-16

12.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-24

Clamp

103002

ET 07-04-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 21/01/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:16:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 31268

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-105. Torque clamps to 80-100 in lb.

25 07-04-16

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207.04.17 @

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-105

Location: _____

PPP Rev: _____

C

7/4/18 SQ

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20710419

Job Completion



U 07-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

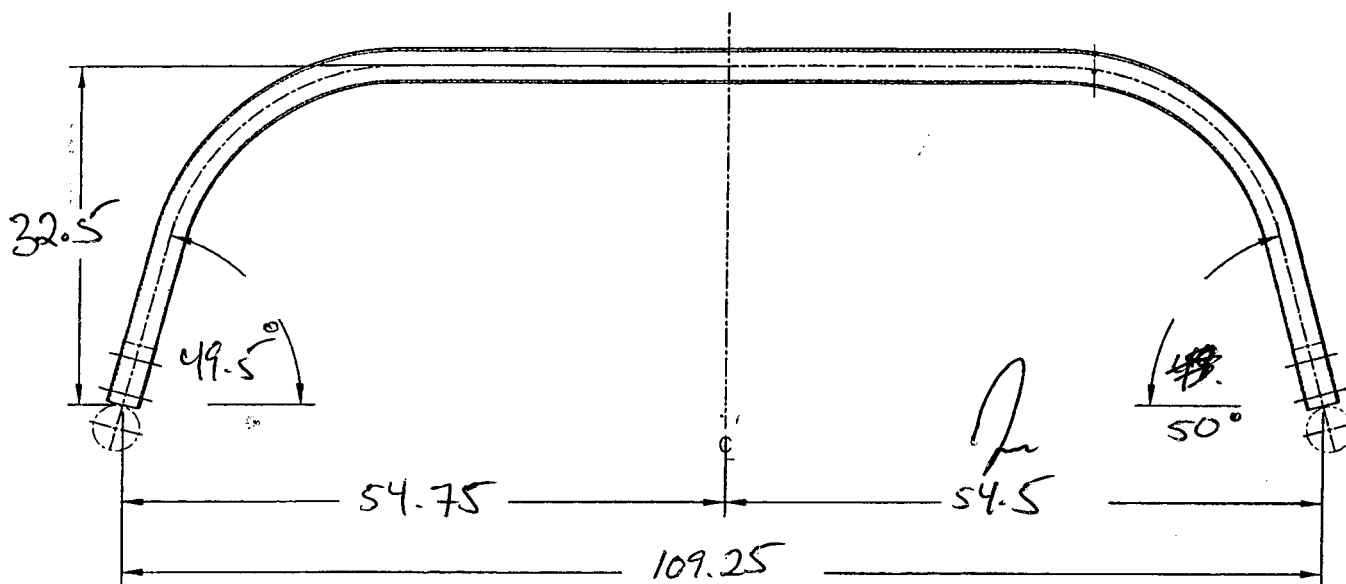
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31268
Description: Crosstube High-High Fwd		Part Number:	D205-596-105
Inspection Dwg: D205-596-105 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	32.4	32.6
1/2 Span	54.6	54.8
Angle	49	52
Total Span	109.2	109.6

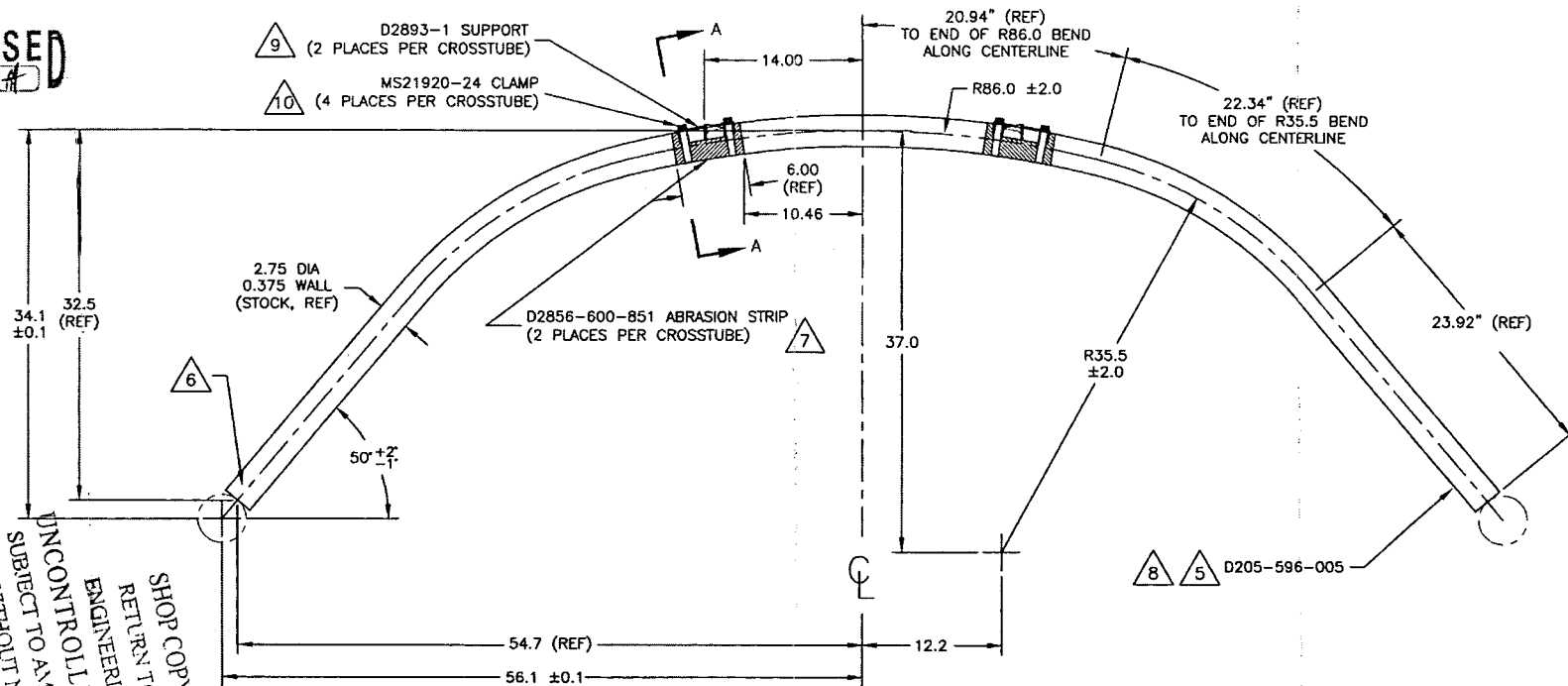


Comments

QC15 Inspection	2051042
Date	0703-28

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

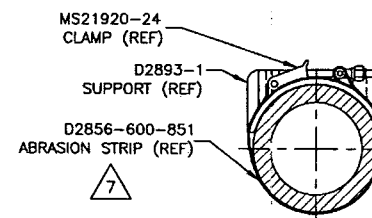
RELEASED
02-11-21



NO 31265
WORK ORDER
SUBJECT TO AENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6005-180
FINISHED LENGTH = 134.40
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005\"
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB



SECTION A-A
SCALE 2:5



COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

A	02.11.20	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D205-596-105
DATE	TITLE	SHEET 1 OF 1
02.11.20	CROSSTUBE FWD EXTENDED	SCALE 1:10